

**UNITED STATES ENVIRONMENTAL PROTECTION AGENCY**

**RCRA COMPLIANCE EVALUATION INSPECTION (CEI)**

**Facility Name:** Flint Hills North Pole Refinery  
(aka Williams)

**Facility EPA ID#:** AKD 00085 0701

**Facility Location:** 1100 H & H Lane  
North Pole, AK 99705

**Facility Contacts:** David Guinn  
Allen Lasiter, President

**Date of Inspection:** June 17, 2004

**Date of Report:** August 20, 2004

**Report Prepared By:** Inspection Team

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**Authority/Purpose:**

The United States Environmental Protection Agency (EPA) intended to secure information regarding Flint Hills North Pole Refinery's compliance with the regulations promulgated under the Resource Conservation and Recovery Act (RCRA) and as amended by the Hazardous and Solid Waste Amendments of 1984 (HSWA). Specifically, regulations found at 40 CFR Part 260 through 270 and Part 279 for the management, transportation, treatment, storage, and disposal of hazardous waste and used oil as defined under these regulations, was investigated. This inspection was carried out under the authority of Section 3007 of RCRA.

## Facility Description:

### Add description from previous years report...

An EPA Compliance Evaluation Inspection in 2003 cited violations of universal waste labeling and dates, hazardous waste labels and dates, and open containers.

A new notification of hazardous waste activity was filed with EPA dated 4/7/04. The new waste stream was K052 from an out of service leaded tank that was cleaned. This was a one-time generation notification.

Following are the findings from this inspection:

#### *Manifest Review*

Manifests from July 2003 to the present were reviewed. **Bruce - got anything on the manifests? Cause the one I wrote down actually ends up being fine...**

#### *Maintenance Building*

The maintenance building operates a glass bead blaster. At the time of this inspection there was a 10-gallon container being managed as satellite accumulation. The container was labeled and being managed appropriately.

This building also operates a parts washer. At the time of this inspection there was a 10-gallon container labeled as "washer sludge" for the solids out of the parts washer. The container was being managed as satellite accumulation. The container was labeled and being managed appropriately.

In a separate satellite accumulation area was a 55-gallon container labeled as hazardous waste ethylene glycol. In the past, this waste stream has not been hazardous but due to the new ownership of the company, the waste was pending new analysis.

In the same satellite accumulation area as the ethylene glycol was a 20-gallon aerosol can puncturing device and container also being managed as satellite accumulation. There were three empty aerosol cans on top of the puncturing device.

EPA has stated that generators can only treat hazardous waste in generator accumulation tanks and containers that are in full compliance with 40 CFR 265 Subparts J and I (51 FR 10145, see page 10168). The requirement under 40 CFR 265 Subparts J and I are designed to ensure that the integrity of the tanks and containers is not breached. EPA considers treatment in accumulation tanks and containers by generators to pose the same level of risk, as would treatment by permitted facilities in similar tanks and containers. Satellite containers are exempt from compliance with the full requirements under Subpart I (40 CFR 262.34(c)). At a minimum for the container being used to treat the aerosol cans to comply with Subpart I (container

management) under Part 265, the container must have an accumulation start date and be marked with the words "Hazardous Waste." In addition, there needs to be weekly inspections and the personnel handling the waste must be trained. The container was not dated with an accumulation start date on the day of this inspection.

The regulations at 40 CFR 262.34(a) state that a generator may accumulate hazardous waste on-site for 90 days or less without a permit or without having interim status provided that the waste is placed in containers.

At the time of this inspection, there were three empty aerosol cans sitting on top of the puncturing device container. EPA has stated that aerosol cans that have not been punctured are considered a hazardous waste (D003).

There were also two 55-gallon containers of used oil in this area labeled appropriately.

#### *Building #249*

Lead acid batteries in this building are recycled.

The satellite accumulation area had three 55-gallon containers labeled as hazardous waste. One container was for crushing of fluorescent lamps, one was a container for puncturing aerosol cans, and the third was labeled as hazardous waste paint waste. Both the lamp crusher and the aerosol can puncturer are considered treatment under RCRA. The containers were not full at the time of this inspection. The total amount of waste accumulated at this time was below the 55-gallon limit for satellite accumulation areas.

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There was also a 55-gallon container labeled as universal waste bulbs dated 4/1/04. The container was labeled and being managed appropriately.

#### *Lab*

The satellite accumulation area inside the lab contained a small jug of spent COD solution.

## **What is the COD solution stuff again?**

The central accumulation area outside the lab is in a yellow tote. Inside the tote at the time of this inspection was a 5-gallon container labeled for mercury waste. The container was empty at the time of this inspection.

### *Outside accumulation area*

The containers observed in this area at the time of this inspection were:

- five 55-gallon containers labeled as non-hazardous sandblast grit
  - a 15-gallon container labeled as “exit sign with tridium” dated 5/3/04
  - a 55-gallon container labeled as hazardous waste misc. sludge (K050, F037) dated 6/17/04.
- The container wasn’t full at the time of this inspection but fills quickly so is managed as a less than 90-day accumulation area.
- a large tote labeled as hazardous waste spent filters dated 6/17/04

There were lots of empty containers in this area as well.

Hazardous waste waters generated at this facility typically are hazardous for benzene (D018) that comes from the desalting process. Before the water goes into the lagoons, 2/3 of it goes through the bio treatment system. One-third of the water goes through the waste water system. Each stream has to be below .5ppm for benzene for either to go to the lagoons. If one stream comes back above .5ppm and one comes back below .5ppm, neither stream will go to the lagoons, instead they will both be run back through the system and testing again until both meet the .5ppm limit.

Heat exchanger cleaning typically occurs annually and typically consists of 30 to 40 exchangers. The cleaning didn’t happen this year due to the transition in ownership.

## **Closing/Summary**

Both Mr. Guinn and Mr. Lasiter represented Flint Hills during the out briefing. The EPA inspection team discussed the rules about generator treatment being managed in a less than 90-day area as opposed to satellite accumulation.

The EPA inspection team also discussed aerosol cans as being a hazardous waste for reactivity (D003) and that therefore they needed to be managed in a closed and labeled container.

This inspection ended at approximately 3:35pm local time.